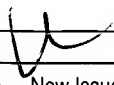


Date: Thursday, 13/11/2008 8:20:42 AM  
 User: Linda Lacelle

## Process Sheet

|                                    |  |                           |             |
|------------------------------------|--|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> :     | WEARSHOE    |
| <b>Job Number</b> :                | 43406  |                           |             |
| <b>Estimate Number</b> :           | 12740  |                           |             |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D353523     |
| <b>This Issue</b> :                | 13/11/2008   | <b>S.O. No.</b> :         |             |
| <b>Prsht Rev.</b> :                | NC   | <b>Drawing Number</b> :   | D3535 REV B |
| <b>First Issue</b> :               | / /  | <b>Project Number</b> :   | N/A         |
| <b>Previous Run</b> :              | 39134  | <b>Drawing Revision</b> : | B           |
| <b>Written By</b> :                |       | <b>Material</b> :         |             |
| <b>Checked &amp; Approved By</b> : |  | <b>Due Date</b> :         | 28/11/2008  |
| <b>Comment</b> :                   | Est Rev:A New Issue 07-02-15 JLM<br>Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC |                           |             |

Qty: 10 Um: Each

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Of Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



**Comment:** Qty.: 1.4296 sf(s)/Unit Total : 14.2958 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 109088 B8-11-18

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3535  
 Dwg Rev: B  
 Prog Rev: B

B8-11-18

B

2-Deburr if necessary B8-11-18

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

S08/11/18 (13)

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



**Comment:** NC BRAKE  
 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
 2-Form joggle as per Dwg D3535 using Jig DT8158  
 3-Identify as D3535-23

S08/11/24 (13)  
 S08/11/24 (13)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 8:20:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43406

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sosululzu (x13)

7.0

POWDER COATING

POWDER COATING



M109648



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30  
320°F  
12:00

M-1 08/11/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OE-11-24

(x13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-21

M-1 08/11/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



MF 08-11-24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

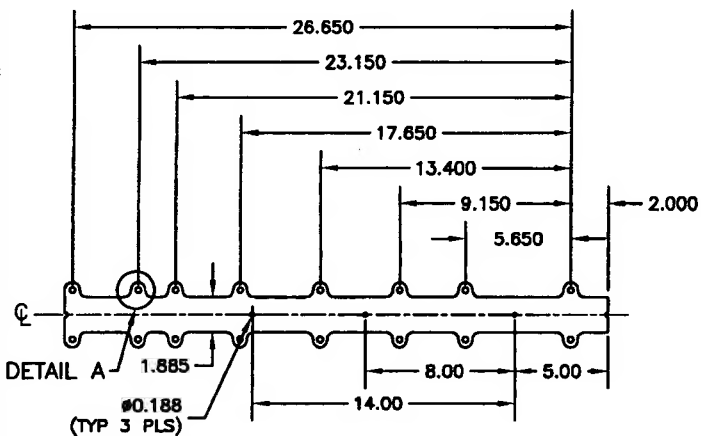
**NOTE:** Date & initial all entries

**DART**

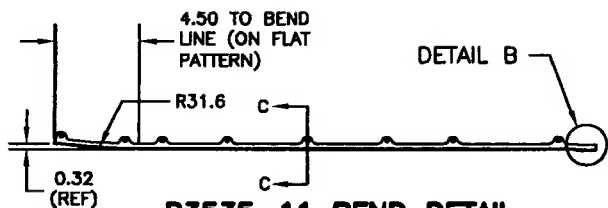
RELEASED

07.04.24

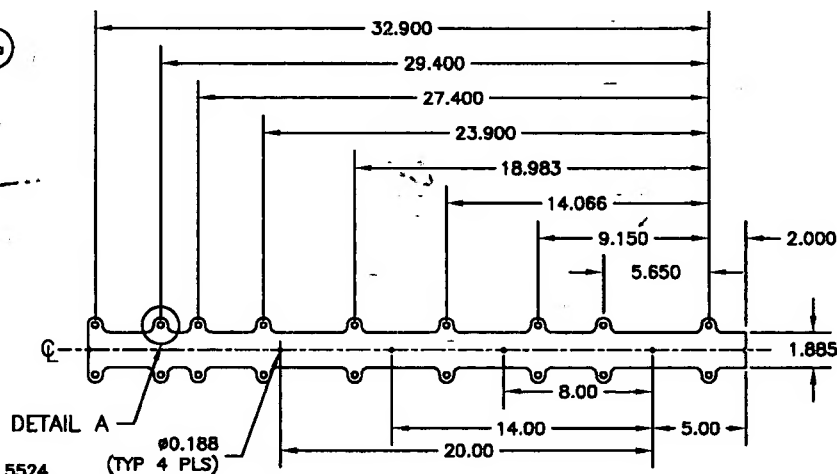
*Handwritten:* m/s 10/09



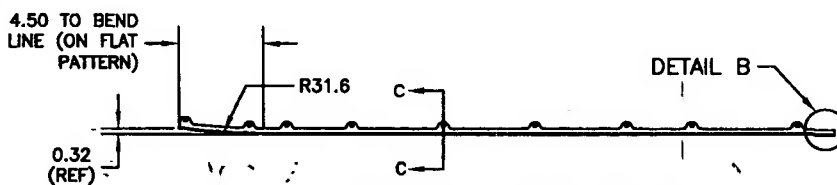
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

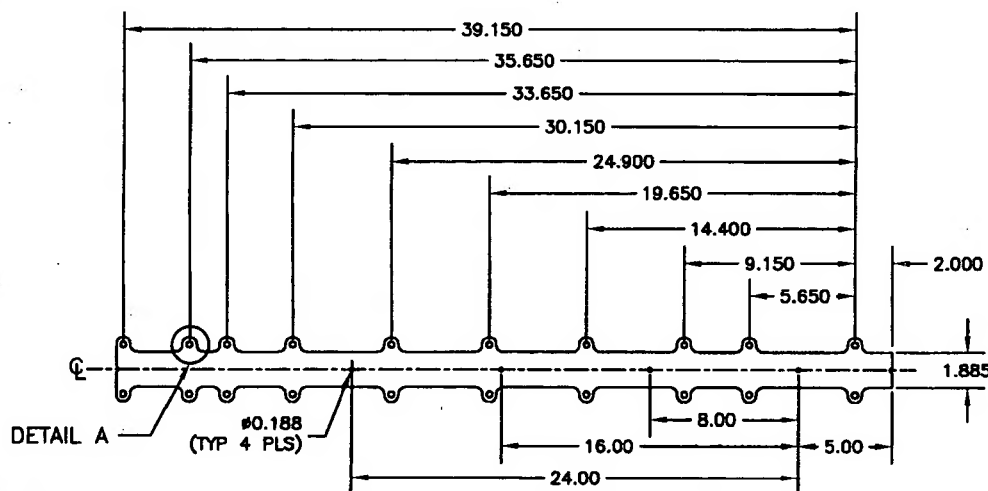
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.        |              |  |
|----------|----------|---------------------------------|--------------|--|
| CB       | PH       | PORT HADLOCK, WA                |              |  |
| CHECKED  | APPROVED | DRAWING NO.                     | REV. B       |  |
|          |          | D3535                           | SHEET 1 OF 7 |  |
| DATE     |          | TITLE                           | SCALE        |  |
| 07.04.17 |          | WEARSHOE                        | 1:10         |  |
| A        | 06.10.25 | NEW ISSUE                       |              |  |
| B        | 07.04.17 | MOVE TAB OUTBOARD, ADD AMS SPEC |              |  |

**DART**

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07.04.24

| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC. |              |
|----------|----------|--------------------------|--------------|
| CB       | PH       | PORT HADLOCK, WA         |              |
| CHECKED  | APPROVED | DRAWING NO.              | REV. B       |
|          |          | D3535                    | SHEET 2 OF 7 |
| DATE     |          | TITLE                    | SCALE        |
| 07.04.17 |          | WEARSHOE                 | 1:10         |



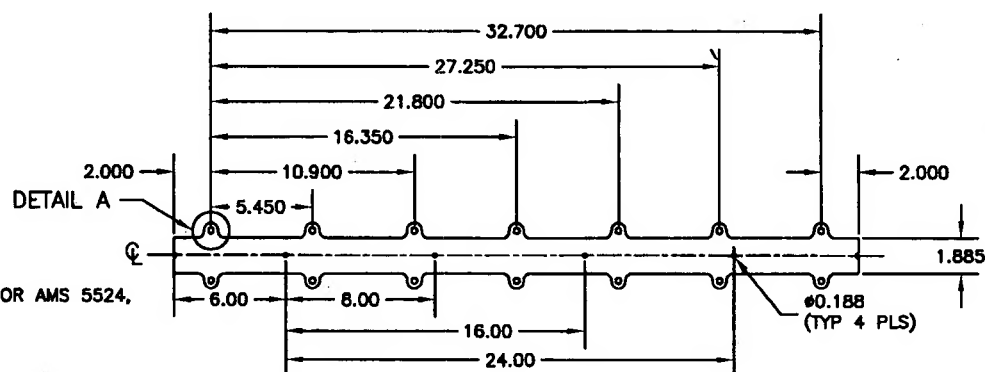
**D3535-15F FLAT PATTERN**

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

0.32  
(REF)

**D3535-15 BEND DETAIL**

W043406



**D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL**

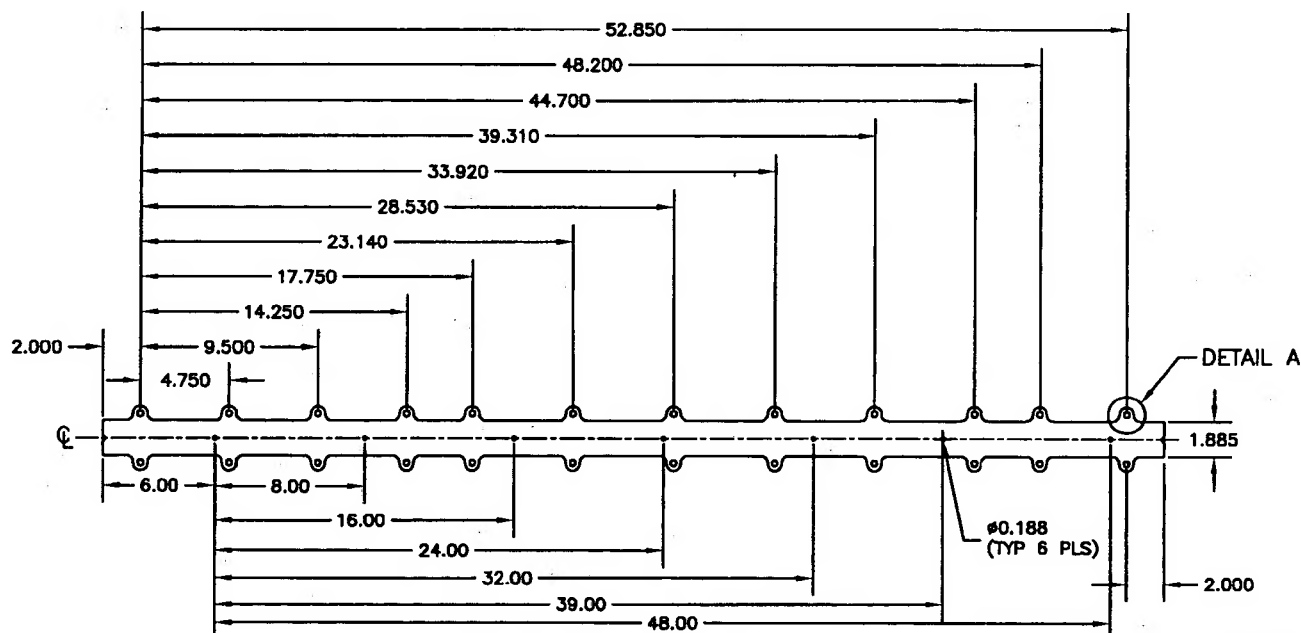
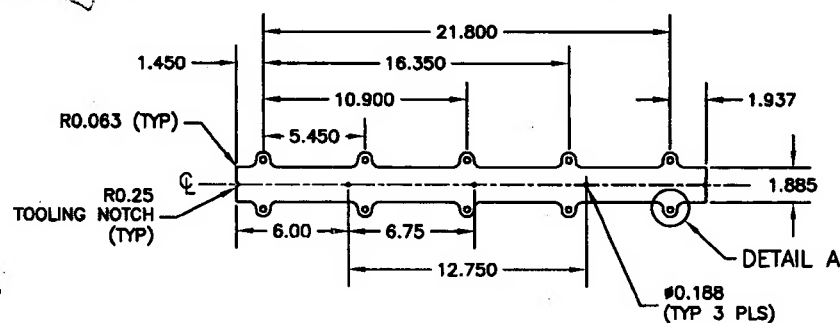
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

07.04.24

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

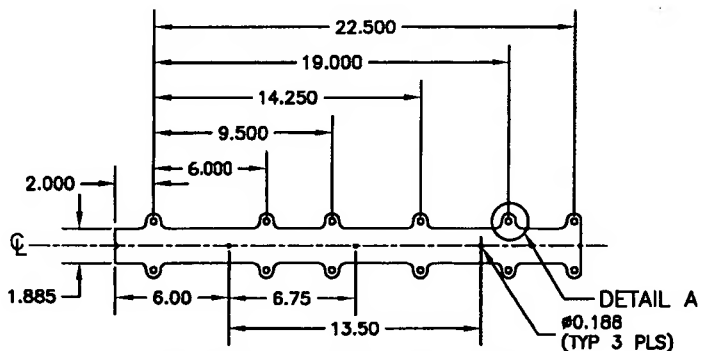
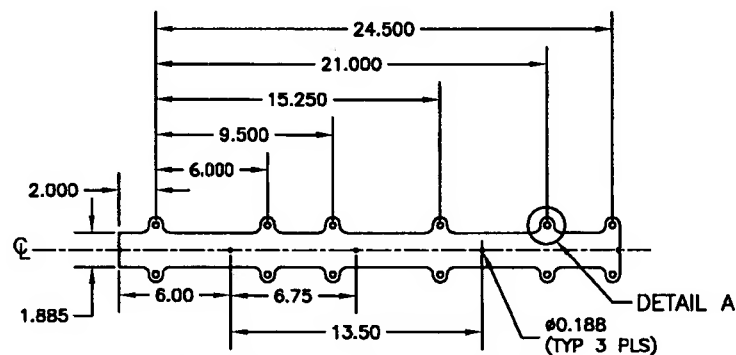
Mo 43406

| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC. |              |
|----------|----------|--------------------------|--------------|
| CB       | PH       | PORT HADLOCK, WA         |              |
| CHECKED  | APPROVED | DRAWING NO.              | REV. B       |
| #        | #        | D3535                    | SHEET 3 OF 7 |
| DATE     | TITLE    | SCALE                    |              |
| 07.04.17 | WEARSHOE | 1:10                     |              |

**DART**

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07.04.24

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

W043406

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC. | REV. B       |
|----------|----------|--------------------------|--------------|
| CB       | PH       | PORT HADLOCK, WA         |              |
| CHECKED  | APPROVED | DRAWING NO.              | SHEET 4 OF 7 |
|          |          | D3535                    |              |
| DATE     | TITLE    | SCALE                    |              |
| 07.04.17 | WEARSHOE | 1:10                     |              |

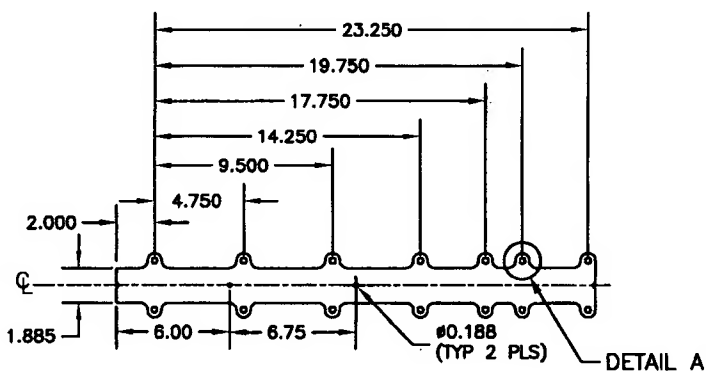
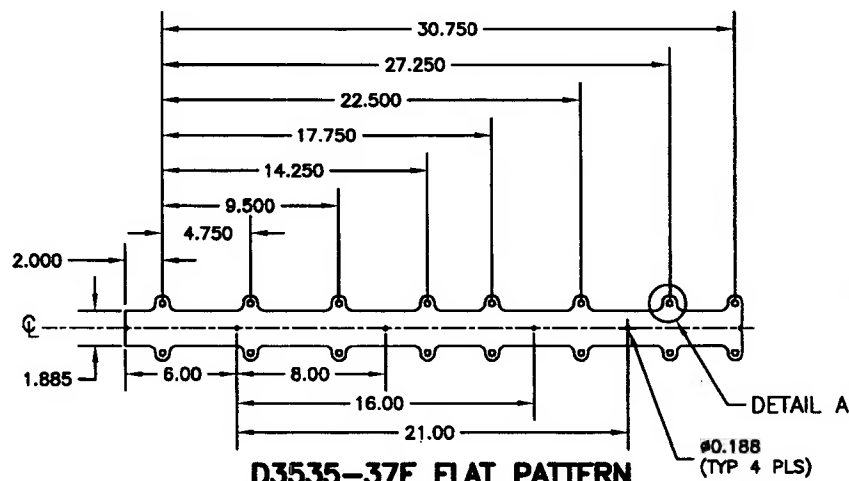


**DART**

RELEASED

07.04.17

| DESIGN             | DRAWN BY           | DART AEROSPACE USA, INC. |              |
|--------------------|--------------------|--------------------------|--------------|
| CB                 | PH                 | PORT HADLOCK, WA         |              |
| CHECKED            | APPROVED           | DRAWING NO.              | REV. B       |
| <i>[Signature]</i> | <i>[Signature]</i> | D3535                    | SHEET 5 OF 7 |
| DATE               | TITLE              | WEARSHOE                 | SCALE        |
| 07.04.17           |                    |                          | 1:10         |

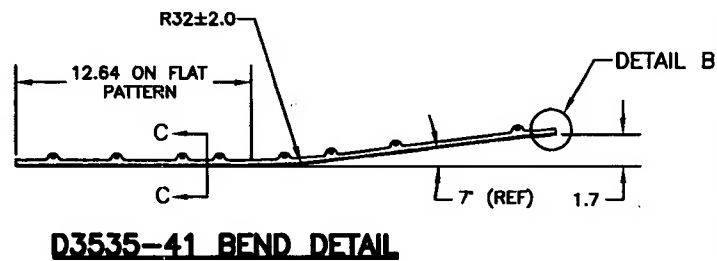
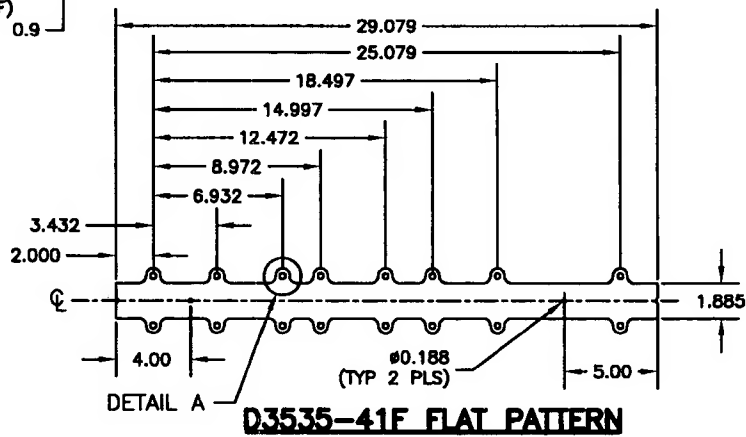
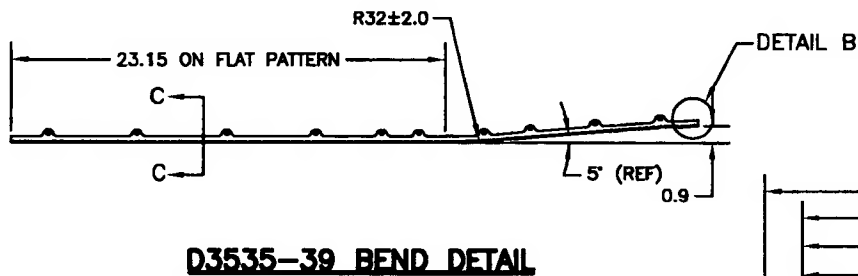
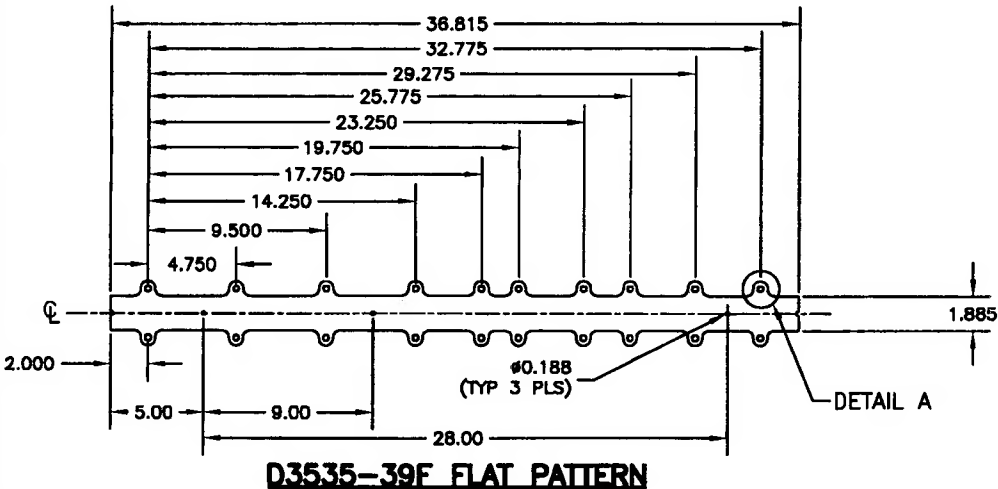
**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

*No 43406*

# DART

07.04.24





## NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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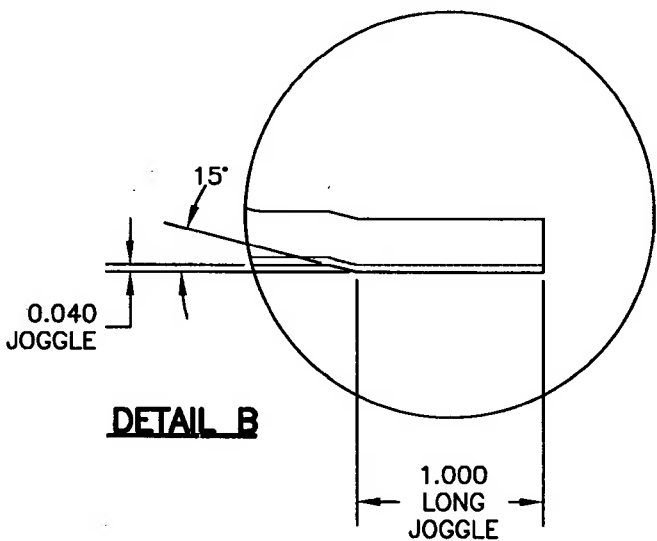
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|  |   |   |                        |
|--|---|---|------------------------|
| DESIGN<br><b>CB</b>  | DRAWN BY<br><b>PH</b>   | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |                        |
| CHECKED<br> | APPROVED<br> | DRAWING NO.<br><b>D3535</b>                         | REV. B<br>SHEET 6 OF 7 |
| DATE<br><b>07.04.17</b>  | TITLE<br><b>WEARSHOE</b>  |   | SCALE<br><b>1:10</b>   |

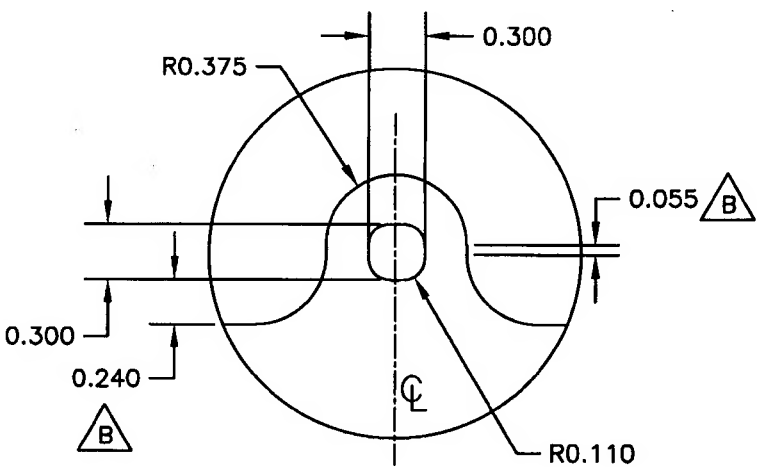
**DART**

RELEASED  
07.04.24

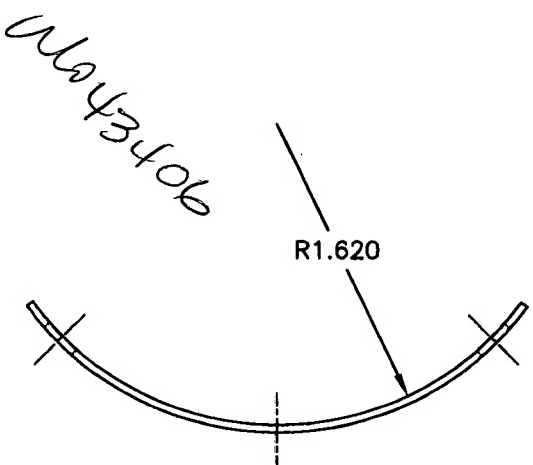
|                               |                                |  |                     |
|-------------------------------|--------------------------------|--|---------------------|
| DESIGN<br><b>CB</b>           | DRAWN BY<br><b>PH</b>          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                     |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3535</b>                  | REV. B              |
| DATE<br><b>07.04.17</b>       | TITLE<br><b>WEARSHOE</b>       | SHEET 7 OF 7                                 | SCALE<br><b>1:1</b> |



**DETAIL B**



**DETAIL A**



**SECTION C-C**

0643406

|  |  |                              |
|--|--|------------------------------|
| <b>DART AÉROSPACE LTD</b>              |  | <b>Work Order:</b> 43406     |
| <b>Description:</b> WEAR SHAFT         |  | <b>Part Number:</b> D3535-23 |
| <b>Inspection Dwg:</b> D3535-33 Rev: B |  | <b>Page 1 of 1</b>           |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .188            | + .005 - .001 | .190             | X      |        |                      |          |
| 300 X 300         | ± .010        | 302 X 303        | *      |        |                      |          |
| 1.885             | ± .010        | 1.888            | X      |        |                      |          |
| 2.000             | ± .010        | 2.000            | *      |        |                      |          |
| 2.000             | ± .010        | 2.000            | *      |        |                      |          |
| 6.00              | ± .030        | 6.00             | X      |        |                      |          |
| 8.00              | ± .030        | 9.00             | X      |        |                      |          |
| 16.00             | ± .030        | 16.00            | X      |        |                      |          |
| 24.00             | ± .030        | 24.00            | X      |        |                      |          |
| 32.00             | ± .030        | 32.00            | X      |        |                      |          |
| 39.00             | ± .030        | 39.00            | X      |        |                      |          |
| 48.00             | ± .030        | 48.00            | X      |        |                      |          |
| 4.750             | ± .010        | 4.751            | X      |        |                      |          |
| 9.500             | ± .010        | 9.503            | X      |        |                      |          |
| 14.250            | ± .010        | 14.250           | X      |        |                      |          |
| 17.750            | ± .010        | 17.750           | X      |        |                      |          |
| 23.140            | ± .010        | 23.140           | X      |        |                      |          |
| 28.530            | ± .010        | 28.530           | X      |        |                      |          |
| 33.920            | ± .010        | 33.920           | X      |        |                      |          |
| 39.310            | ± .010        | 39.310           | X      |        |                      |          |
| 44.700            | ± .010        | 44.700           | X      |        |                      |          |
| 48.200            | ± .010        | 48.200           | X      |        |                      |          |
| 52.850            | ± .010        | 52.850           | X      |        |                      |          |

|                        |                       |
|------------------------|-----------------------|
| <b>Measured by:</b> PB | <b>Audited by:</b> S  |
| <b>Date:</b> 8-11-18   | <b>Date:</b> 08/11/18 |

|                              |
|------------------------------|
| <b>Prototype Approval:</b> A |
| <b>Date:</b> A               |

|            |             |               |                   |                 |
|------------|-------------|---------------|-------------------|-----------------|
| <b>Rev</b> | <b>Date</b> | <b>Change</b> | <b>Revised by</b> | <b>Approved</b> |
| A          |             | New Issue     | KJ/JLM            |                 |